| Work Orde September-14-12 | | | | *90 | 1209* | | | | | | | Page 1 |
|---|---|------------------------------------|------------------------------|-------------------------|---------------------|------------|--------------|---------------|------------|---------------|------------------|----------------|
| Revision ID: | D350-607-54 | | A | Accept | *N900 | 040 | 100 |)* | Setup | Start Stop | 1.71 | S1* S2* |
| Start Date: Required Date: Reference: | 9/12/12 10/12/12 | Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | | Cust Item Customer: | ID: | | | | | | |
| Approvals: | Process Pla | n: MLJ | Date: 12-09-14 | Tooling: | D | ate: | - | | Run | Start | *N | R1* |
| | | | | SPC (Y/N): | | ate: | | | | Stop | *N | R2* |
| Sequence ID/ Work Center II | D | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Rej Qty | | Reject Number | Insp. Stamp |
| Draw Nbr | Rev | ision Nbr | | | | | | | | | | |
| D350-607-3 | Α | | | | | | | | t. | _ | | |
| *100 *100* | *************************************** | DOCUMENT CONTROL | | 0.00 | Wall. | ι <i>γ</i> | | 9 | 1)a | A M | 151 | 2-10-26 |
| DC Document Control | | Memo Photocopy blu | uefile & type labels per PPP | 0.00 D350-607-543 CH | IG004 DAST | 2/10/3/ | | '6 | -) | | | |
| 11.0 | | Pick Kit | | 0.00 | | | | | | | , | |
| *110* Packaging Packaging | | Memo | | 0.00 | | | | | (() | 414. | 25 | |
| 120 | ÷ | QC4- 100% Inspect kits fo | or completeness | 0.00 | DAG | | | i | | | | |
| *120 | | QC4- 100% hispect kits to | on completeness | 0.00 | 15 | | | / | | | | |
| QC Quality Control | | Memo | | 0.00 | 210.30 | | | | | | | |

| | | | | | | | | | | DQA: | Date: | |
|------------------------|-----|------|------|-----|--------|--|-----------|---|---|------------|---|---------------------------|
| NCR: Y | Yes | / No | | | | WORK ORDER NON-C | ONFOR | MANCE / UP | | QA Closed: | Date: | |
| Work Orde | ar. | | | | | DISPOSITION | | | AGAINST DE | PARTMENT | /PROCESS | 7 |
| Part No. NCR No. Des | | | | | | Rework Scrap Use-as-is Work Order Update | | Skid-tube Machining noforming Large Fab | Crosstube Small Fab Finishing Composite | | Water Jet d. Eng. Coor. re/Packaging Supplier | Engineering Quality Other |
| Root | T | | | | Descri | ption of work order update | Initial | Ad | ction | Sign & | | |
| Cause | | Date | Step | Qty | | or Non-conformance | Chief Eng | Desc | cription | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | |
| Operator | | : | | | | | | | | | | |
| Material | | • | | | | | | | | | | |
| Setup | | | | | | | | | | | | |
| Other | | | | | | | | | | | | |
| Process | | | |] | | = | | | | | | |
| Supplier | | | 1 | | | | | | | | | |

Landing Gear General Grain Ovalized Pressure/Forced Bending Bend BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Instructions Incomplete/Unclear Wrong Stock Pulled Part Lost/Missing Crushed/Crimped. Burrs Maintenance Cuffs Contamination Part Moved Mislabeled Countersink Positioned Wrong Heat Treat Misread Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Offset Ripples in Bend Drill Holes Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Turning Sequence Finish

Outside Dimensions

FAULT CATEGORY

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Training Unapproved

| Work Orde | | | | *902 | 09* | | | | | | Page 2 |
|---|---------------------------------------|---|----------------------|------------------------------------|----------------------------|-------------------|---------------|----------|---------------|-----------------------------------|----------------|
| Item ID: Revision ID: | D350-607-5 | | | Accept | *N90004 | L 0100 |)* | Setup | Start Stop | *N: | S1* |
| Item Name: Start Date: Required Date: Reference: | Heli-Utility-E 9/12/12 10/12/12 | Start Qty: 1.00 Req'd Qty: 1.00 | *1* *1* | | Cust Item ID: Customer: | | | | эцор | ^N: | S2* |
| Approvals: | Process Pla | an: | Date: | Tooling: SPC (Y/N): | Date: | | | Run | Start Stop | *N *N | R1* R2* |
| Sequence ID/ Work Center II 130 *130* Packaging Packaging | D | Operation Description Pick Kit Memo Package as | per PPPD350-607-543 | Set Up/ Run Hours 0.00 3k | | ol # Plan Code | Accept Qty | Re Qt | | Reject Number (2) <i>IC</i> | Insp. Stamp |
| 140 *140* QC Quality Control | | QC21- Final Inspection • Memo | - Work Order Release | 0.00 | | | | | 10 | AW, | _ |

1210-31

| | | | | | | | | | | | DQA: | Date: | * |
|--|--|--------|------|----------|-------------|----------------------------|-----------------|----------------|-------------|--------------|--------------------|------------------|---------------------------------------|
| NCR: | Yes / | / No | | | | WORK ORDER NON-C | O | NFORM | /ANCE / UP | DATE | 04.61 | Data | |
| | | - | - | | | | -1 | | | | QA Closed: | Date: | |
| NA/ - wie Owale | ~~. | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | /PROCESS | • |
| Work Orde | er | | | | | Rework | 1 | | Skid-tube | Crosstube | 1 | Water Jet | Engineering . |
| Part N | No. | | | | | Scrap | | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| | ···- | | | | | Use-as-is | | | noforming | Finishing | 4 | re/Packaging | Other |
| NCR I | No | | | | | Work Order Update | | | Large Fab | Composite |] | Supplier | |
| | | | | | | | | | | | T | 1 | · · · · · · · · · · · · · · · · · · · |
| Root | | | | | | ption of work order update | 1 | nitial | | tion | Sign & | | |
| Cause | | Date | Step | Qty | (| or Non-conformance | Ch | ief Eng | Desc | ription | Date | Verification | QC Inspector |
| Doc/Data | Ш | | | | | | | | | | | | |
| Equip/Tooling | Ш | | | | | | | 1 | : | | | | |
| Operator | Ш | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | |
| Setup | Щ, | * | | | | | | . 1 | | | | | |
| Other` | Ш | | | | | | | ! | | | | | |
| Process | Ш | | | · | | | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | Ш | | | | | | | | | | | | |
| Unapproved | | | | <u> </u> | | | <u> </u> | | | | | | |
| | | | | | | | AUL | T CATE | GORY | <u></u> | | | |
| Landi | | | | | | General | _ | 1 | | _ | ٦ | | ٦ |
| | ⊢ | ending | | | | Bend | \vdash | Grain | | | Ovalized | | Pressure/Forced |
| Centre Not Concentric to O/S BOM/Route | | | | | | <u> </u> | Hardwa | | <u> </u> | Over/Unde | | Temperature/Cure | |
| Cracks Broken/Damaged | | | | | | - | 4 | ion Incomplete | ,, <u> </u> | Part Incorre | | Weld | |
| Crushed/Crimped. Burrs | | | | | _ | 1 | ions Incomplete | /Unclear | Part Lost/N | | Wrong Stock Pulled | | |
| │ | | | | | | Contamination | <u></u> | Mainte | | | Part Moved | | |
| | Heat Treat Countersink | | | | | | _ | Mislabe | | | Positioned | | ¬ |
| | Inspection Strip in Tube Cut Too Short | | | | | Cut Too Short | | Misread | t | | Power Loss | /Surge | Other |

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print September-14-12 9:49:22 AM Work Order ID: 90209 D350-607-543 **Start Date: 9/12/12** Parent Item: Heli-Utility-Basket Parent Item Name: Start Qty: 1.00 IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP REV:B 12.03.06 AS PER Comments: ECN12-535 DD VERF:EC IPP REV:C 12.07.24 AS PER ECN 12-610 DD VERF:EC Component Item ID/ Qty per Kit Total Replacement Mfg/ Last Unit of Oty on Bin Route Qty Primary Item Name Item ID Location Seq ID Measure Hand Item Location Qty Issued Purch D350-607-511 No 110 5.0000 Manufactured Each **Quick Release Basket Mounting Installation** Location Loc Qty Loc Code Smo FG032 89085 PK12 87114 87115 89087 PK13 89086 D2690-6 110 No Each 30.0000 Manufactured Lanyard Assembly Location Loc Qty Loc Code ST014 26 88553 10 89371 16 ST017 4 86926 4

110

Each

Eyebolt Receiver Assembly Location Loc Oty ST072 14 87076 14 D4030-043 110 Each No Manufactured Long Basket Assembly, Light Lid (350)

No

Manufactured

Smp

D3912±0411

Page 1

Required Date: 10/12/12

Required Qty: 1.00

Status Date

Issued 14.0000 Loc Code 0.0000

| | | | | | | | | | | DQA: | Date: | |
|------------------------|----------|----------|----------|----------------|----------------------------|---------|----------------|-------------------------|---------------|--------------|---------------|--------------------|
| NCR: Y | es / No | | | | WORK ORDER NON-C | CON | NFORM | MANCE / UPDATE | | QA Closed: | Date: | |
| 187 - 11. O - 1 | | | | | DISPOSITION | | | AGAINS | T DE | PARTMENT/ | PROCESS | • |
| Work Orde | er: | | | | Rework | 1 | | Skid-tube Crosstub | <u></u> | | Water Jet | Engineering . |
| Part N | lo | | | | Scrap Use-as-is | | 1 | Machining Small Fa | b | 1 | d. Eng. Coor. | Quality Other |
| NCR No | | | | | Work Order Update | | | Large Fab Composit | _ | ilec/stor | Supplier | |
| Root | | | | Descri | ption of work order update | | nitial | Action | | Sign & | | |
| Cause | Date | Step | Qty | (| or Non-conformance | Ch | ief Eng | Description | | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | | |
| Equip/Tooling | | | ļ | | | | | | | | | |
| Operator | | | | | | | | | | | | |
| Material | | | | | | | | | | | |] |
| Setup | | | | : | | | | | | | | |
| Other | | | | | | | | | | | | |
| Process | | | | · | | | | | | | | |
| Supplier | | | | | | | | | | | | |
| Training | | | | | | 1 | | | | | • | |
| Unapproved | | | | | | | | | | | | |
| | | | | | F | AUL | T CATE | GORY | | | | |
| Landi | ng Gear | | | | General | _ | | | | _ | - | 7 |
| | Bending | | | | Bend | | Grain | | L | Ovalized | | Pressure/Forced |
| | Centre N | ot Conce | ntric to | o/s | BOM/Route | L | Hardwa | re | | Over/Under | tolerance | Temperature/Cure |
| Cracks | | | | Broken/Damaged | | Inspect | ion Incomplete | | Part Incorred | ct | Weld | |
| | Crushed/ | /Crimped | - | | Burrs | | Instruct | ions Incomplete/Unclear | | Part Lost/Mi | ssing | Wrong Stock Pulled |
| ` | Cuffs | | | | Contamination | | Mainte | enance | | Part Moved | | |
| Heat Treat | | | | | Countersink | | Mislabe | eled | | Positioned V | Vrong | |

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio September-14-12 9:49:22 AM

| Work Order ID: | 90209 | | | | | | | | | |
|----------------------------------|---------------------|--------------|----|----------------|---------|-------|----------|----------------|---|-----|
| Parent Item: | D350-607-543 | | | | | | Start | Date: 9/12/12 | Required Date: 10/12/12 | |
| Parent Item Name: | Heli-Utility-Basket | | | | | | Star | rt Qty: 1.00 | Required Qty: 1.00 | |
| D4085-3 Placard, Instructions | | Manufactured | No | | 110 | Each | 28.0000 | Û | 1 - 6 | 8 |
| | | | | Location | Loc Qty | | Loc Code | | | |
| SKI | | | | ST092 | 4 | | | | - | |
| | | | | 87037 | 4 | | | | _ | |
| | | | | ST095 | 24 | | | | 70 | |
| GWARM ONG | | | | 87738 | 24 | | | 8/13 | | |
| D4086-215. Placard, Max Load | | Manufactured | No | | 110 | Each | 6.0000 | | 1 - // | |
| _ | | | | | | | | | | |
| Smb | | | | Location | Loc Qty | | Loc Code | | | |
| | | | | ST095 87674 | 6 | | | 87676 | <u>ر</u> | |
| D4151-041 | | Manufactured | No | 0/0/4 | 110 | Each | 10.0000 | | 7. ———————————————————————————————————— | |
| Basket Fwd Hardpoint A | ssembly, Lower | Mandidetured | | | | 244.1 | 10.000 | | 1 St217 G | |
| - ~ | | | | Location | Loc Qty | | Loc Code | | | |
| Sm | | | | GA | -4 | | | | | |
| • | | | | ST101 | 10 | | | | - · | |
| | | | | 87150 | 10 | | | | _ | |
| | | | | ST103 | 4 | | | | _ | |
| D4151:043 | | Manufactured | No | | 110 | Each | 11.0000 | | 1 / | 1 |
| Basket Fwd Hardpoint A | ssembly, Upper | | | | | | | | - WYO | 25 |
| Smo | | | | Location | Loc Qty | | Loc Code | | 1- Busho | |
| 21.0 | | | | ST101 | 9 | | | -0.7 | 1 | (1) |
| | | | | 87694 | 6 | | | <u> + 1674</u> | | |
| | | | | 88559 | 3 | | | | _ | |
| | | | | ST103 | 2 | | | | · = | |
| | | | | 85795 | 2 | | | | , | |

| | | | | | | | | | | | DQA: | Date | : <u> </u> |
|---------------|------------------|-----------|----------|----------|-----|----------------------------|----------|---------|-----------------------|-------------|--------------|---------------|--------------------|
| NCR: | Yes | / No | | | | WORK ORDER NON-C | CON | IFORN | MANCE / UPDAT | | QA Closed: | Date | |
| | | | | | | <u> </u> | | | | | QA Closed: | Date | · |
| Work Orde | ~ ×· | | | | | DISPOSITION | 1 | | A | AGAINST DEI | PARTMENT | PROCESS | • |
| WOLK OLU | = - | | | | | Rework | 1 | | Skid-tube C | rosstube | | Water Jet | Engineering . |
| Part N | No. | | | | | Scrap | 1 | | \vdash | mall Fab | Pro | d. Eng. Coor. | Quality |
| | - | | | | | Use-as-is | 1 | | ~ — | Finishing | | re/Packaging | Other |
| NCR I | No. | | | | | Work Order Update | 1 | | Large Fab Co | omposite | | Supplier | |
| | | | | | | | | | | | | | |
| Root | | | | | l | ption of work order update | 1 | nitial | Action | | Sign & | | |
| Cause | | Date | Step | Qty | (| or Non-conformance | Chi | ief Eng | Description | on | Date | Verification | QC Inspector |
| Doc/Data | Ш | |] | | | | | | | | | | |
| Equip/Tooling | Ш | | | | | | | | | | | | |
| Operator | Ш | | | | | | | | | | | | |
| Material | Ш | | | | | | | | | * | | | |
| Setup | Ш | | | | | | | | | | | | |
| Other | Ш | | | | | | | | | | | | |
| Process | Ш | | | | | | | | | | | | |
| Supplier | Ш | | ļ | | | | | | | | | | |
| Training | Ш | | | | | | | | | | | - | |
| Unapproved | | | | | | | <u> </u> | | | | | | |
| | | | | | | | AUL' | T CATE | GORY | ,. | | | <u> </u> |
| Landi | ng G | iear | | | _ | General | | | | | 1 | r- | _ |
| F-4 ~ F-4 | | | | | | Bend | | Grain | | | Ovalized | <u> </u> | Pressure/Forced |
| | Ш | Centre No | ot Conce | ntric to | O/S | BOM/Route | Ш | Hardwa | re | | Over/Under | tolerance | Temperature/Cure |
| | Cracks | | | | | Broken/Damaged | - | | on Incomplete | | Part Incorre | - | Weld |
| | Crushed/Crimped_ | | | | | Burrs | \vdash | | ions Incomplete/Uncle | | Part Lost/M | | Wrong Stock Pulled |
| | | Cuffs | | | 1 | Contamination | | Mainte | nance | | Part Moved | | |

Mislabeled

Out of Calibration
Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

September-14-12 9:49:23 AM

| Work Order ID: | 90209 | | | | | | | | | | |
|-----------------------|---------------------|--------------|----|----------|--------|---------|------|-------------|--|----|-------------------------|
| Parent Item: | D350-607-543 | | | | | | | | rt Date: 9/12/12 | | Required Date: 10/12/12 |
| Parent Item Name: | Heli-Utility-Basket | | | | | | | Sta | art Qty: 1.00 | | Required Qty: 1.00 |
| D1150±0±11 | | Manufactured | No | | | 110 | Each | 21.0000 | 0 | 1 | |
| Attachment Arm Assemb | ly | | | | | | | | | | |
| | | | | Location | | Loc Oty | | Loc Code | | | |
| ~ ~ | | | | ST100 | | 17 | | | | | |
| SmD | | | | | 87402 | 7 | | | | | |
| | | | | | 88367 | 2 | | | 892 | 22 | |
| | | | | | 89232 | 8 | | | | | |
| | | | | ST134 | | 4 | | | | _ | |
| | | | | | 82300 | 0 | | | | | _ |
| | | | | | 85791 | 4 | | | | | |
| NAHBA Bolt | | Purchased | No | | | 110 | Each | 1,747.000 | 67 | 6 | |
| | | | | Location | | Loc Qty | | Loc Code | | | |
| 5 | | | | ST356 | | 1554 | | | | | |
| 3MP> | | | | | 122416 | 500 | | | 12241 | 76 | |
| | | | | | 122808 | 554 | | | / | | |
| • | | | | | 122993 | 500 | | | | | |
| | | | | ST357 | | 193 | | | | _ | |
| | | | | | 120187 | 193 | | | | | |
| | | | | | 120770 | 12 | | | | | |
| | | | | | 121652 | 161 | | | | | |
| | | | | | 122063 | 101 | | | | | _ |
| N4GIS OLT | | Purchased | No | | | 110 | Each | 43.0000 | | 1 | - Confisher |
| | | | | Location | | Loc Oty | | Loc Code | | | |
| | | | | ST357 | | 20 | | | | | |
| m D | | | | | 122808 | 20 | | | | _ | |
| <i>>⊓ , 1</i> | | | | | 122000 | | | | | | • |
| | | | | ST358 | | 23 | | | | _ | |
| | | | | | 120124 | 1 | | | 13.11. | | |
| | | | | | 121146 | 22 | | | <u>12119</u> | 6 | |

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS DISPOSITION** Work Order: Engineering Rework Skid-tube Crosstube Water Jet Prod. Eng. Coor. Machining Small Fab Quality Scrap Part No. Thermoforming Finishing Rec/Store/Packaging Other Use-as-is Supplier Work Order Update Large Fab Composite NCR No. Description of work order update Initial Action Sign & Root Chief Eng Description Verification QC Inspector or Non-conformance Date Qty Date Step Cause Doc/Data Equip/Tooling Operator Material Setup Other

| | | | FAU | LT CATEGORY | | |
|---------|------------------------------|----------------|-----|---------------------------------|----------------------|--------------------|
| Landing | Gear | General | | | | _ |
| | Bending | Bend | | Grain | Ovalized | Pressure/Forced |
| | Centre Not Concentric to O/S | BOM/Route | | Hardware | Over/Under tolerance | Temperature/Cure |
| | Cracks | Broken/Damaged | | Inspection Incomplete | Part Incorrect | Weld |
| | Crushed/Crimped. | Burrs | | Instructions Incomplete/Unclear | Part Lost/Missing | Wrong Stock Pulled |
| | Cuffs | Contamination | | Maintenance | Part Moved | _ |
| | Heat Treat | Countersink | | Mislabeled | Positioned Wrong | _ |
| | Inspection Strip in Tube | Cut Too Short | | Misread | Power Loss/Surge | Other |
| | Ripples in Bend | Drill Holes | | Offset | - | |
| | Torque Waves in Extrusion | Drawing | | Out of Calibration | | |
| | Turning Sequence | Finish | | Out of Sequence | | |

Outside Dimensions

Wave/Twist in Tube

Folio

Process
Supplier
Training
Unapproved

September-14-12 9:49:23 AM

Work Order ID: 90209 D350-607-543 **Start Date:** 9/12/12 Parent Item: Required Date: 10/12/12 Heli-Utility-Basket Parent Item Name: Start Qty: 1.00 Required Qty: 1.00 AN310G4 No 110 Each Purchased 115.0000 Nut Location Loc Qty Loc Code ST343 100 122800 50 122800 122993 50 ST344 15 120360 121166 121444 Purchased No 110 Each 29.0000 PIN, QUICK RELEASE Location Loc Code Loc Qty 331 122452 ST315 3 114340 118612 2 ST331 20 1 12/1/25 122800 20 Purchased No 110 Each 6,398.0000 Location Loc Qty Loc Code 314 3369 122452 3369 FP001 16 8182 16 ST300 13 121444 13 ST314 3000 123021 3000

| | | | | | | | | | | | | DQA: | Date | <u>:</u> | .e. |
|---------------|--|-----------|------------|---|---------|----------------------------|------|----------|--------------------|-----------|---------------|--------------|---------------|------------|--------------------|
| NCR: | Yes | / No | | | | WORK ORDER NON- | COI | NFORI\ | ANCE / UPDA | ATE | | · | | | |
| | | • | | _ | | | | | | | | QA Closed: | Date | <u>)</u> : | |
| Work Orde | ۰.۰ | | | | | DISPOSITION | | | | AGAINST | DEI | PARTMENT | PROCESS | | • |
| Work Orde | ۲۰. | | | | | Rework | 7 | | Skid-tube | Crosstube | | | Water Jet | \neg | Engineering . |
| Part N | No. | | | | | Scrap | 1 | | Machining | Small Fab | $\overline{}$ | Pro | d. Eng. Coor. | 7 | Quality |
| | • | | | - | | Use-as-is |] | Therm | noforming | Finishing | | Rec/Stor | re/Packaging | | Other |
| NCR I | ۷o. | | | Work Order Update Large Fab Composite Sup | | | | | | | | Supplier | | | |
| Root | | | | | Descri | ption of work order update | | Initial | Actio | n | | Sign & | | | |
| Cause | | Date | Step | Qty | C | or Non-conformance | Ch | nief Eng | Descrip | tion | | Date | Verification | \perp | QC Inspector |
| Doc/Data | | | | | | | | : | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | | |
| Operator | | | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | | |
| Setup | | | | | | | | | | | | | | | |
| Other | | | | | | | | | | | | | | | |
| Process | | | 1 | | | | 1 | | | | | | | | |
| Supplier | | | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | | | |
| Unapproved | | | | | L | | | | | *** | | <u> </u> | L | \perp | |
| | | | | | | | FAUI | LT CATE | GORY | | | | | | |
| Landi | _ | 1 | | | | General | _ | 7 | | | | 1 | Г | _ | |
| | | Bending | | | ٠ ـ ـ | Bend | _ | Grain | | | <u> </u> | Ovalized | | — | Pressure/Forced |
| | | Centre N | ot Conce | ntric to | o/s | BOM/Route | _ | Hardwa | | | | Over/Under | } | _ | Temperature/Cure |
| · · | $ldsymbol{ld}}}}}}$ | Cracks | | | | Broken/Damaged | | ⊣ ` | ion Incomplete | | | Part Incorre | F | _ | Weld |
| | $oxed{oxed}$ | Crushed/ | Crimped | | Ŀ | Burrs | | | ions Incomplete/Un | nclear | \vdash | Part Lost/M | | ' | Wrong Stock Pulled |
| | _ | Cuffs | | | <u></u> | Contamination | L | Mainte | | | \vdash | Part Moved | | | |
| | | Heat Trea | at | | | Countersink | | Mislabe | | | \perp | Positioned \ | _ | | |
| | | Inspectio | n Strip in | Tube | | Cut Too Short | | Misread | t | | L | Power Loss, | /Surge | | Other |
| | Ripples in Bend Drill Holes | | | | | | | Offset | | | | | | | |

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Picklist Print

September-14-12 9:49:23 AM

Page 5

| Work Order ID: Parent Item: Parent Item Name: | 90209 D350-607-543 Heli-Utility-Basket | | | | | | | art Date: 9/12/12 art Qty: 1.00 | | equired Date: 10/1 | 2/12 |
|---|--|-----------|----|-------------------------|--------------|-------------------|------------|---|---|--------------------|------|
| MS24665-151 Cotter-Rin | | Purchased | No | | 110 | Eacl | h 303.0000 | 1 | 1 | -() | |
| SK | \Diamond | | | Location ST309 | <u>Loc (</u> | Oty 103 103 | Loc Code | | | | |
| | | | | ST323 | | 200 200 | | 12,280 | <u>2</u> | 1 | |
| NASISISHUL WASHER | | Purchased | No | | 110 | Eacl | h 367.0000 | 25 | 2 — | | |
| / | | | | Location | Loc | <u>Oty</u> | Loc Code | | | | |
| SMO | | | | FG 10369 | 1 | 8 8 | | | | | |
| | | | | ST277 | | 359 2 | | | — — | | |
| NAS1149F0432P Washer | - | Purchased | No | 12039 | 110 | 357 Eacl | h 978.0000 | 1203 | ر ای 12 سے 12 | -// | |
| w asiaci | | | | Location | Loc | <u>Qty</u> | Loc Code | CORRESPONDE AND | *************************************** | | |
| Sms | | | | 275 12244 | 1 | 594 594 | | 7 | | | |
| , | | | | ST275 | | 384 15 | | 10.116 | — ~ 1 | | |
| NAS1149@0463R | | Purchased | No | 12215 | 110 | 369 Eacl | h 666.0000 | 12110 | $\frac{1}{3}$ | / Osh /2 | - di |
| Washer | | | | Location | Loc | | Loc Code | CITY SECURITY LATTICE, The Additional Conference Confere | W. Sala | 1 27192 | |
| · | | | | FP001 11535 | 8 | 1 | | | _ | | |
| SMP | | | | ST297 11773 11909 | 5 | 665 17 648 | | 1190 | - - 9 1 | | |

| NCR: Y | es / No | | | | WORK ORDER NON-C | CON | FORM | MANCE / UP | DATE | | | |
|--------------|--|------------|----------|-------------------|----------------------------|----------|----------|-----------------|------------|--------------|---------------|--------------------|
| | | | | | | | | | | QA Closed: | Date | |
| Work Orde | er: | | | | DISPOSITION | | | | AGAINST DE | PARTMENT, | PROCESS | , |
| | | | | | Rework |] [| | Skid-tube | Crosstube | | Water Jet | Engineering |
| Part N | lo. | | | | Scrap | | 1 | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| | | | | | Use-as-is | | Therm | noforming | Finishing | Rec/Stor | e/Packaging | Other |
| NCR N | lo | | | | Work Order Update |] | | Large Fab | Composite | | Supplier | |
| | | | | | | | | | <u></u> | T | | 7 |
| Root | | | | | ption of work order update | 1 | nitial | | ction | Sign & | | |
| Cause | Date | Step | Qty | | or Non-conformance | Chi | ef Eng | Desc | cription | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | | |
| quip/Tooling | _ | | | | | | | : | | | | |
| Operator | | 1 | | | | | | | | | | |
| Material | | | | | | | | ! | | | | |
| Setup | | | | | | ļ · | | | | | | |
| Other | | | | | | | | | | | | |
| Process | | | | | | | | | | | | |
| Supplier | | | , | | | | | | | | | |
| Training | | | | / | • | | | | | | | |
| Unapproved | | <u> </u> | | 1 | _ | | | 600% | | <u> </u> | | |
| | | | | | | AULI | CATE | GORY | | | | |
| Landii | ng Gear | | | | General | | C | | _ | ۱ | _ | 7,5,, /5,, |
| | Bending | _ | | | Bend | - | Grain | | ļ | Ovalized | _ | Pressure/Forced |
| | _ | ot Conce | ntric to | ^{O/S} - | BOM/Route | \vdash | Hardwa | | <u> </u> | Over/Under | <u> </u> | Temperature/Cure |
| | Cracks | | | - | Broken/Damaged | \vdash | | ion Incomplete | , <u> </u> | Part Incorre | ⊢ | Weld |
| • | Crushed | Crimped. | • | F | Burrs | \vdash | | ions Incomplete | /Unclear | Part Lost/M | ssing | Wrong Stock Pulled |
| | Cuffs | | | | Contamination | - | Mainte | | | Part Moved | | |
| | Heat Tre | | | ļ | Countersink | \vdash | Mislabe | | <u> </u> | Positioned \ | | ٦ |
| | Inspection Strip in Tube Cut Too Short | | | | | \vdash | Misread | d | | Power Loss/ | Surge | Other |
| | Ripples in | | | <u> </u> | Drill Holes | \vdash | Offset | | | | | |
| į | Torque V | Mayos in I | Extrucio | n 1 | Drawing | 1 1 | Out of (| ^alibration | | | | |

Out of Sequence
Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

REFERENCE ONLY

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4.0 WEIGHT AND BALANCE

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|--|------------------|-----------------------|---------------------------|------------------|------------------------|
| | | Arm | Moment | Arm | Moment |
| D350-607-541 | 80.7 lb | ± 49.1 in | ± 3962 in-lb | 135 in | 10895 in-lb |
| (Standard Basket) | 36.6 kg | ± 1.25 m | ± 45.8 m-kg | 3.43 m | 125.5 m-kg |
| D350-607-543 | 65.7 lb | ± 49.1 in | ± 3226 in-lb | 135 in | 8870 in-lb |
| (Lightweight Basket) | 29.8 kg | ± 1.25 m | ± 37.3 m-kg | 3.43 m | 102.2 m-kg |
| D350-607-545 | 58.7 lb | ± 49.1 in | ± 2882 in-lb | 135 in | 7925 in-lb |
| (Standard Basket) | 26.2 kg | ± 1.25m | ± 32,8 m-kg | 3.43 m | 89.9 m-kg |
| D350-607-547 | 47.7 lb | ± 49.1 in | ± 2342 in-lb | 135 in | 6440 in-lb |
| (Lightweight Basket) | 21.6 kg | ± 1.25 m | ± 27.0 m-kg | 3.43 m | 74.1 m-kg |
| D350-607-511 (Quick Release Basket Mounting Kit) | 7.2 lb 3.3 kg | ± 36.9 in ± 0.94 m | ± 266 in-lb ± 3.1 m-kg | 135 in 3.43 m | 972 in-lb 11.3 m-kg |

5.0 PARTS LIST

| QTY | rQŦY. | QTY | QTY | QTY | QTY | PART NUMBER | DESCRIPTION |
|----------|---------------------|-------|--------------|------|---------------|-----------------|-----------------------------------|
| -541 | -543 | -545 | -547 | -511 | -501 | | |
| X | | | | | | D350-607-541 | HELI-UTILITY-BASKET |
| | X | | | | | D350-607-543 | HELI-UTILITY-BASKET |
| | | Х | | | | D350-607-545 | HELI-UTILITY-BASKET |
| | | | X | | | D350-607-547 | HELI-UTILITY-BASKET |
| 1 | V | 1_ | | —x= | | | QUICK RELEASE BASKET MOUNTING KIT |
| | | | | | X | D350-607-501 | CONVERSION KIT |
| | | | | | | | TEA NIVA-DD- |
| 1 | | 1 | | | 1 | D2690-6 | "LANYARD = |
| | | | | 4 | 4 | D3910-3 | X-TUBE LUG |
| 1 | | | | | 1 | D3912-041 | EYEBOLT RECEIVER ASSY |
| | | | | 8 | 8 | D3984-030 | RUBBER EXTRUSION, X-TUBE |
| 1 | | | | | - | D4030-041 | LONG BASKET ASSY |
| | | | | | | :D4030-043 | LONG BASKET-ASSY, LIGHTWEIGHT |
| | | 1 | | | | D4032-041 | SHORT BASKET ASSY |
| | | | 1 | | | D4032-043 | SHORT BASKET ASSY, LIGHTWEIGHT |
| 1 | | | | | | D4085-3 | *PLACARD-INSTRUCTIONS |
| 1 | | | | | 1 | D4086-200 | PLACARD, MAX LOAD |
| | 4 | | | | | *D4086-215 | *PLACARD, MAX LOAD |
| | | 1 | | | 1 | D4086-220 | PLACARD, MAX LOAD |
| | | | 1 | | 1 | D4086-232 | PLACARD, MAX LOAD |
| | | | | 11 | 1 | D4148-041 | FWD X-TUBE LUG ASSY |
| | | | | 1 | 1 | D4149-041 | AFT X-TUBE LUG ASSY |
| 1 | _1 | | | | 1 | D4150-041 | *ATTACHMENT ARM ASSY |
| 1 | | 1 | | | 1 | D4151-041 | BASKET FWD HARDPOINT ASSY (LOWER) |
| 1 | 1 | 1 | 1 | | 1 | D4151-043 | BASKET FWD HARDPOINT ASSY (UPPER) |
| 6 | -6= | ==6== | 6 | | 6= | -AN4-13A | -BOLT |
| <u> </u> | <u> </u> | | | 16 | 16 | AN4-14A | BOLT |
| 1 | _1 | 1 | ==1=- | | ==1== | FAN4C15 | FBOLT |
| 1 | | | 1 | | | EAN310C4 | -CASTELLATED NUT |
| 1 | | 1-1 | 1_ | | 1== | MS17984-C413 | FQUICK RELEASE PIN |
| 6 | = 6 = | -6- | 6 | =16= | -22 | MS21042L4 | NUT (OR MS21042-4) |
| 1 | | | 1 | | <u>1</u> | MS24665-151 | :COTTER-PIN |
| | | - 2 | 2 | | | -NAS1515H4L | -WASHER |
| 12 | | 12 | 12 | -32- | -44 | -NAS1149F0432P | -WASHER |
| 3 | | - 3: | 3 | - JZ | 3: | NAS1149C0463R— | -WASHER |
| <u> </u> | <u> </u> | | | | | -1.0.0±00±001/- | 1 |

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